

CLAIMS

1. A steel pipe pole base reinforced with ribs welded to said steel pipe pole base in the form of a T-joint, characterized by forming peening processed portions at weld toes by ultrasonic vibration.

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2. A steel pipe pole base according to claim 1, characterized by said ribs being tabular ribs.

3. A steel pipe pole base according to claim 1, characterized by said ribs being inverted-U or inverted-V shaped ribs bent at the upper end portions.

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4. A method for reinforcing a steel pipe pole base according to any one of claims 1 to 3, characterized by applying peening treatment to weld toes by ultrasonic vibration after said tabular ribs, inverted-U shaped ribs or inverted-V shaped ribs are welded to said steel pipe pole base in the form of a T-joint.

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5. A method for reinforcing a steel pipe pole base according to claim 4, characterized by applying peening treatment to said weld toes by ultrasonic vibration while a load is imposed on said steel pipe pole base so as to impose a tensile stress in the direction of the steel pipe axis on the base material in the region subjected to said peening treatment.

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6. A method for reinforcing a steel pipe pole base according to claim 4 or 5, characterized by applying said peening treatment by ultrasonic vibration under the conditions of 20 to 50 μm in amplitude and several tens of kHz in frequency.

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